

Work Order ID 71053

Tuesday, June 21, 2011 1:30:08 PM

Page 1

Item ID: D206-642-441

Accept

Setup Start

Revision ID:

Stop

Item Name: Replacement Skidtube

Start Date: 6/21/2011 Start Qty: 1.00

Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 11-06-21

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run Start

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D2650

Rev F

100

0.00



DOCUMENT CONTROL

DC

0.00

Memo

Document Control

Photocopy bluefile and create labels per PPP D206-642-441 CHG002

N/A

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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NOTE: Date & initial all entries

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Page 2

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

110

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Deburr Fwd edge of tube

2-Remove ridge on inside of Fwd edge of tube as per Dwg D2650

3-Weld Fwd Cap as per Dwg D2650. Use aluminum rod. Grind D2647 to fit as required.

A/R ☐ Aluminum Rod M112860 / M117456 BE 11/06/28

4-Grind weld flush to cap on top surface only. BE 11/06/28

5-Cut aft end 138.60" from front of tube

6-Drill pilot holes using drill jig DT8025 & DT8169 (A,B,C,D). Open to Ø0.312".

7-Drill holes for wearplates using DT 8028-7. Open to Ø 0.297".

8-Open using #6 Drill Bit

9-Open holes for Tow Ring to Ø0.625" as per Dwg D2650, D2650-7 Drilling Detail

10-Remove inner indexing ridge on aft end of skidtubes as per Dwg D2650

11-Deburr and Blow out all chips from inside the tube

BE 11/06/28

BE 11/06/29

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 3

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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

115

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

8/11/06/30

Quality Control

116

QC10- Inspect visual per QSI004- ground welds

0.00



QC

Memo

0.00

8/11/06/30

Quality Control

120

Chemical Conversion Coat per QSI005 4.1

0.00



HandFinish

Memo

0.00

Hand Finishing

1 0 3AD 11-06-20

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Page 4

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Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

QC3- Inspect Part Finish

0.00



QC

Memo

0.00

Quality Control

11-6-30

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Tuesday, June 21, 2011 1:30:08 PM



Page 5

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Item Name: Replacement Skidtube

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

| Sequence ID/ Work Center ID | Operation Description | Set Up/ Run Hours | Tool ID | Tool # | Plan Code | Accept Qty | Reject Qty | Reject Number | Insp. Stamp |
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|
|--------------------------------|--------------------------|----------------------|---------|--------|--------------|---------------|---------------|------------------|----------------|

140

0.00



Skidtubes

Skidtubes

Memo

0.00

1-Open holes to finished size as per Dwg D2650, D2650-7 Drilling Detail
(without cutting fluid)

2-Countersink crossbolt spacer holes as per Dwg D2650(without cutting fluid)

3-Deburr. Blow out chips. Grind alodine off around crossbolt spacer.

4-Bond D2654-7 web in place as per QSI 015Ensure holes line upAllow 12 Hrs.
cure time before cutting☐

Start Date: 11/07/04

Time: ☐ 11:00am☐

Finish Date: 11/07/05

Time: ☐ 2:00A/R ☐ Sikaflex-291 ☐ 1116945Sikaflex expiry date: ☐ 12/01/15

Dr 11/07/04

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Work Order ID 71053

Tuesday, June 21, 2011 1:30:08 PM



Page 6

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Item Name: Replacement Skidtube

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

150

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

1 0 BE 11/07/05

160

Skidtubes

0.00



Skidtubes

Memo

0.00

Skidtubes

1-Prep per QSI 005 and Insert cross bolt spacers D2649. Weld as per QSI 004 and Dwg D2650. Remember to back drill each hole to 0.25" before welding the other side. Use aluminum rod.
A/R Aluminum Rod M112860

2-Grind welds flush as per Dwg D2650.

DL 11/07/06

3-Counterbore 5/16" x 0.750" deep as per Dwg D2650 Deburr

BE 11/07/06

BE 11/07/05

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 71053

Tuesday, June 21, 2011 1:30:09 PM

Page 7

Item ID: D206-642-441

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Start Date: 6/21/2011 Start Qty: 1.00

Required Date: 7/8/2011 Req'd Qty: 1.00

Reference:

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

QC:

Date:

SPC (Y/N):

Date:

Run

Start

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

170



Skidtubes

Skidtubes

HandFinishing

0.00

Memo

0.00

Install D2680-041 Nut Plate as per Dwg D2650

1 8 BEU/07/06

180



QC

Quality Control

QC10- Inspect visual per QSI004- ground welds

0.00

Memo

0.00

① 11-07-06

190



QC

Quality Control

QC5- Inspect part completeness to step on W/O

0.00

Memo

0.00

11-07-06

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Work Order ID 71053

Tuesday, June 21, 2011 1:30:09 PM



Page 8

Item ID: D206-642-441

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Setup Start



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Item Name: Replacement Skidtube

Start Date: 6/21/2011 Start Qty: 1.00



Cust Item ID:

Required Date: 7/8/2011 Req'd Qty: 1.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

200

Pressure Wash per QSI005 4.3

0.00



HandFinish

Memo

0.00

Hand Finishing

Brush alodine tube on crossbolt spacer area, do not acid etch, do not dip tube in tank.

1 0 11-7-12

215

0.00



SprayPaint

Memo

0.00

Spray Painting

PRIME B 117319
DEFLEET BLUE B 118395
DEFLEET CLEAR B 117984

RT 11 07 20

225

QC14- Inspect Spray Paint

0.00



QC

Memo

0.00

Quality Control

11 07 21 11

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ **PAR #:** _____ **Fault Category:** _____ **NCR:** Yes No **DQA:** _____ **Date:** _____
Resolution: _____ **Disposition:** _____ **QA: N/C Closed:** _____ **Date:** _____

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Work Order ID 71053

Tuesday, June 21, 2011 1:30:09 PM



Page 9

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

230

0.00



HandFinish

HandFinishing

Memo

0.00

Hand Finishing

1-Install inserts & wearpads as per dwg D2922. Use a drop of Sikaflex inside insert holes before installing wearpad/wearplate.

✓ A/R ☐ Sikaflex-291 ☐ 11116046Sikaflex expiry date: ☐ 11168

✓ 2-Install O-Rings D2651-3 on plugs D2651-1 with Petroleum Jelly and install plugs as per Dwg D2650. Clean excess adhesive

— 3-Install MS27039-4-06 Screw as per DEO 9153

✓ 4-Inspect for foreign object per QSI 024

5-Install D2646 Aft Cap and seal with SikaflexClean excess adhesive

✓ A/R ☐ Sikaflex-291 ☐ 11116046Sikaflex expiry date: ☐ 11168

— 6-Wing Walk as per Dwg D2650-7 and QSI 005 4.4

Batch: 11117863

1 0 1116046 11168

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Tuesday, June 21, 2011 1:30:09 PM



Page 10

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Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

240

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

11/17/28 ①

250

Packaging

0.00



Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPP D206-642-441

Location:

PPP Rev:

PFP 71046

11/17/28 ①

260

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

11/17/29 ②

11-0708

| W/O: | | WORK ORDER CHANGES | | | | | |
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NOTE: Date & initial all entries

Tuesday, June 21, 2011 1:30:16 PM

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

Comments: IPP Rev:H 05.10.11 Added D3429-1 per CHG002 KJ/CP/JLM
 IPP Rev:I 08-05-01 add QC3 DD verified by:EC
 IPP Rev:J 08-09-29 revF as per dwg DD verified by: EC IPP rev K
 10.09.27 SS washers for wearplates EC verified by: DD

[illegible]

Dart Aerospace Ltd

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:30:16 PM

Page 2

Work Order ID: 71053

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

CCR264SS3-3

Purchased No

170 Each

569.0000

2 2



Cherry Rivet



BE 11/07/06

Location

Loc Qty

Loc Code

FP-B

2

113973

2

ST311

567

117086

71

117849

496

2 2

D2649

Manufactured No

170 Each

111.0000

23 23



Cross Bolt Spacer



BE 11/07/05
B 71355 23

Location

Loc Qty

Loc Code

LG

99

68224

2

70394

97

LG001

12

65317

1

68507

11

D2680-041

Manufactured No

170 Each

30.0000

1 1



Nut Plate



BE 11/07/00

Location

Loc Qty

Loc Code

ST020

30

55366

17

70088

13

Tuesday, June 21, 2011 1:30:16 PM

Shop Packet Print

Page 2

Dart Aerospace Ltd

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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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| | | | | | | | | |

NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:30:16 PM

Page 3

Work Order ID: 71053

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

ALS4-1032-130

Purchased

No

230

Each

1,478.000

60

60



Insert



HL 11/07/20

Location

Loc Qty

Loc Code

ST281

8

M118386

X60

117331

8

ST282

1470

117717

1470

AN960JD10L

NAS1149D0332J

Purchased

No

230

Each

0.0000

2

2



Washer

M117087



(x2) HL 11/07/20

AN960JD416

NAS1149D0463J

Purchased

No

230

Each

0.0000

1

1



Washer

M116805



(x1) HL 11/07/20

CR3212-4-03

Purchased

No

230

Each

1,216.000

2

2



Cherry Rivet



HL 11/07/20

Location

Loc Qty

Loc Code

FP-B

2

110139

2

ST311

1214

114859

1214

2

Tuesday, June 21, 2011 1:30:17 PM

Shop Packet Print

Page 3

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:30:17 PM

Page 4

Work Order ID: 71053

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

D2651-1 Manufactured No 230 Each 251.0000 22 22



Plug



HL 11/07/26

Location

Loc Qty

Loc Code

fpa

109

B70942

X10

69018

109

FP-A

142

B71037

X12

57869

1

66445

10

67760

97

70827

30

70839

4

D2651-3 Manufactured No 230 Each 536.0000 22 22



O-Ring



HL 11/07/26

Location

Loc Qty

Loc Code

FP-A

536

61962

104

66956

432

X22

D3535-15 Manufactured No 230 Each 27.0000 1 1



Wearshoe



HL 11/07/26

Location

Loc Qty

Loc Code

FP018

27

66558

7

68358

6

69931

14

X1

Tuesday, June 21, 2011 1:30:17 PM

Shop Packet Print

Page 4

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:30:17 PM

Page 5

Work Order ID: 71053

Parent Item: D206-642-441



Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|--------------------|
| D3535-23 | Manufactured | No | 230 | Each | 20.0000 | 1 | 1 |
|  | | | | | |  | <u>21 11/07/26</u> |

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP021 | 20 | |
| 66236 | -1 | |
| 67594 | 8 | |
| 68342 | 13 | |

| | | | | | | | |
|---|--------------|----|-----|------|--------|---|--------------------|
| D3535-37 | Manufactured | No | 230 | Each | 3.0000 | 1 | 1 |
|  | | | | | |  | <u>21 11/07/26</u> |

Wearshoe

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP018 | 3 | 1371668 |
| 67612 | 3 | |

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|--------------------|
| D3536-15 | Manufactured | No | 230 | Each | 17.0000 | 1 | 1 |
|  | | | | | |  | <u>21 11/07/26</u> |

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP011 | 17 | |
| 66559 | 17 | |

| | | | | | | | |
|---|--------------|----|-----|------|---------|---|--------------------|
| D3536-23 | Manufactured | No | 230 | Each | 39.0000 | 1 | 1 |
|  | | | | | |  | <u>21 11/07/26</u> |

Gasket

| <u>Location</u> | <u>Loc Qty</u> | <u>Loc Code</u> |
|-----------------|----------------|-----------------|
| FP011 | 39 | |
| 43406 | 1 | |
| 66560 | 12 | |
| 69902 | 26 | |

Tuesday, June 21, 2011 1:30:17 PM

Shop Packet Print

Page 5

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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NOTE: Date & initial all entries

Picklist Print

Tuesday, June 21, 2011 1:30:18 PM

Work Order ID: 71053

Parent Item: D206-642-441

Parent Item Name: Replacement Skidtube

Start Date: 6/21/2011

Required Date: 7/8/2011

Start Qty: 1.00

Required Qty: 1.00

MS27039-4-06

Purchased

No

230

Each

57.0000

1

1



1107/26

Screw

Location

Loc Qty

Loc Code

FP-A

23

115460

23

ST292

34

115460

34

MS27039C1-08

Purchased

No

230

Each

1,304.000

60

60



1107/26

SCREW

Location

Loc Qty

Loc Code

FP-A

1

116022

1

ST293

1303

116373

3

117291

800

118077

500

NAS1149C0332R

Purchased

No

230

Each

1,630.000

60

60



1107/26

Washer

Location

Loc Qty

Loc Code

FP-B

15

117291

15

ST297

1615

116304

55

117460

330

117887

830

118078

400

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

| QTY -1 | QTY -3 | QTY -5 | QTY -7 | PART NUMBER | DESCRIPTION |
|-----------|-----------|-----------|-----------|---------------|---|
| X | | | | D2650-1 | SKIDTUBE ASSEMBLY |
| | X | | | D2650-3 | SKIDTUBE ASSEMBLY |
| | | X | | D2650-5 | SKIDTUBE ASSEMBLY |
| | | | X | D2650-7 | SKIDTUBE ASSEMBLY |
| 1 | 1 | 1 | 1 | D2600-1-160 | EXTRUSION |
| 1 | | | | D2654-1 | WEB |
| | 1 | | | D2654-3 | WEB |
| | | 1 | | D2654-5 | WEB |
| | | | 1 | D2654-7 | WEB |
| 1 | 1 | 1 | 1 | D2646 | AFT CAP |
| 1 | 1 | 1 | 1 | D2647 | CAP |
| 17 | 18 | 19 | 23 | D2649 | CROSS BOLT SPACER |
| 16 | 18 | 14 | 22 | D2651-1 | PLUG |
| 16 | 18 | 14 | 22 | D2651-3 | O-RING |
| 1 | 1 | 1 | 1 | D2680-041 | NUT PLATE |
| 2 | 2 | | | D3286-1 | DOUBLER |
| 2 | 2 | | | D3286-3 | STUD |
| 42 | 44 | 54 | 60 | ALS7-1032-130 | INSERT (or AKS4-1032-130, ALS4-1032-130, ALS7-1032-130) |
| 2 | 2 | 2 | 2 | AN960JD10L | WASHER |
| 2 | 2 | 2 | 2 | CCR264SS3-3 | RIVET |
| 2 | 2 | 2 | 2 | CR3212-4-03 | RIVET |
| 2 | 2 | 2 | 2 | MS27039-1-08 | SCREW |
| 1 | 1 | 1 | 1 | MS27039-4-06 | SCREW |
| 1 | 1 | 1 | 1 | AN960JD416 | WASHER |
| 52 | 52 | | | CR3212-4-04 | RIVET |

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 71053

PL 11-06-21

RELEASED
08-07-23

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: -CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
-POWDER COAT WHITE (4.3.5.1) PER DART QSI 005 4.3
-BLACK ANTI-SKID PAINT AS INDICATED TO 0.5 ABOVE LOCATION RIDGE PER DART QSI 005 4.4
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: N/A
- 8) WELD PER DART QSI 004
- 9) DAMAGE TOLERANCE ON FWD BEND:
THERE SHOULD BE NO VISIBLE WRINKLES IN THE BEND FROM THE GROUND TO A HEIGHT OF 5 INCHES ABOVE THE GROUND. IT IS ACCEPTABLE TO POLISH OUT GOUGES UP TO 0.020 DEEP IN THE BENT PORTION OF THE TUBE. A MAXIMUM REDUCTION IN DIAMETER OF 0.150" IS ACCEPTABLE IN THE BENT PORTION OF THE TUBE.
- 10) BOND WEB INTO OUTER TUBE WITH SIKAFLEX-241/-291 ADHESIVE PER DART QSI 015
- 11) INSERT D2651-1 PLUG C/W D2651-3 O-RING IN HOLES MARKED 'P' (BOTH SIDES OF TUBE)
- 12) DRILL Ø0.297 FOR ALS7-1032-130 INSERTS USING TEMPLATE DT8056-1 ON -1 TUBE, DT8056-3 ON -3 TUBE, DT8056-5 ON -5 TUBE, AND DT8056-7 ON -7 TUBE. INSTALL INSERTS AFTER FINISH.
- 13) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED

| | | | |
|------------|--|--|--------------|
| F | DRAWING UPDATED TO CURRENT STANDARDS. SHT 6 ADDED. ALL SECTION AND DETAIL VIEWS TRANSFERRED TO SHT 6. SHT 1 IN PL PART D2649 QTY UPDATED. SHT 6 SECT C-C GRIND INSTRUCTIONS DELETED FROM NOTE 7 (SEE NCR 239). | AJS | 08.08.08 |
| E | RMOVE CBORE, CHG DRILL, ADD CHAMFER | CP | 06.03.30 |
| D | REDRAW; INCORP. DE09136/9153/9163 MOD GROUND HANDLING ON D2650-1/-3 | CP | 04.05.17 |
| C | CHANGE HOLE PATTERN AND FRONT END | DS | 97.10.29 |
| B | AS MANUFACTURED CHANGES | DS | 97.06.26 |
| A | NEW ISSUE | DS | 97.03.25 |
| REV. | DESCRIPTION | BY | DATE |
| DESIGN | DS | DART AEROSPACE USA, INC PORT HADLOCK, WA | |
| DRAWN | AJS | | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 1 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
| DATE | 08.08.08 | COPYRIGHT © 1997 BY DART AEROSPACE USA, INC THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC. | |

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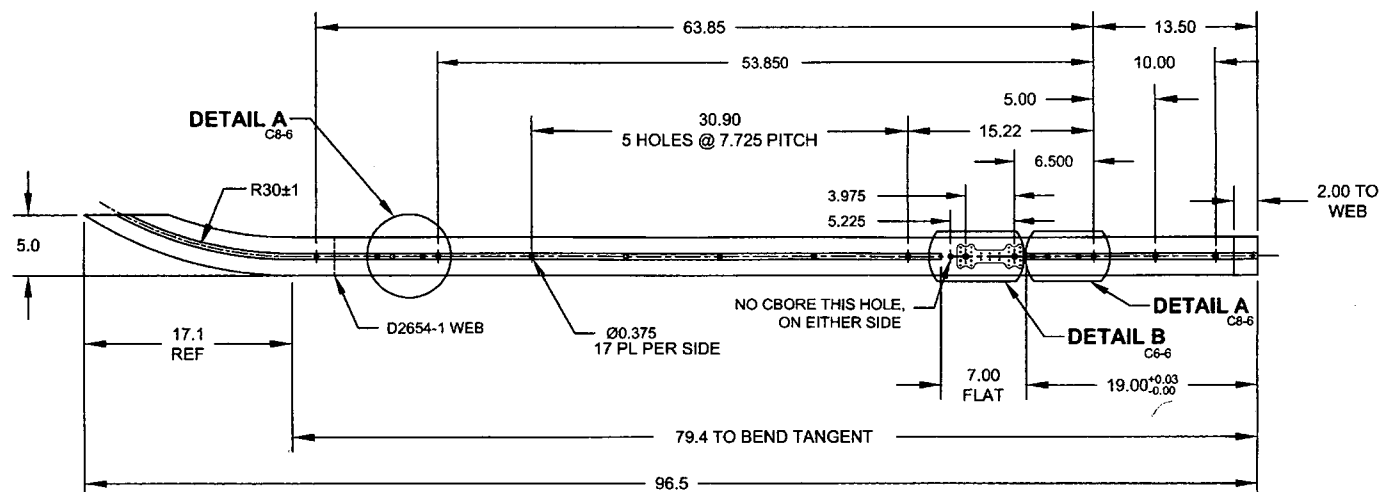
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

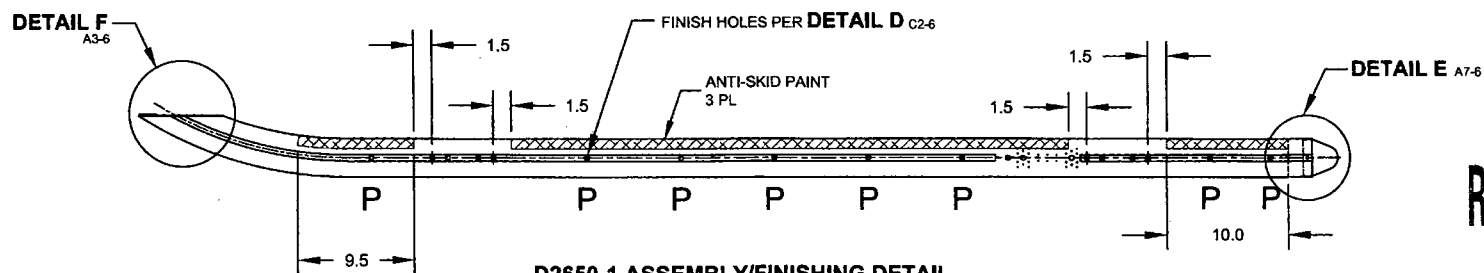
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-1 BENDING/DRILLING DETAIL



D2650-1 ASSEMBLY/FINISHING DETAIL

W/O 71053

RELEASED
680922/100

| | | | |
|------------|----------|--|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED | | DRAWING NO. | REV. F |
| MFG. APPR. | | D2650 | SHEET 2 OF 6 |
| APPROVED | | TITLE | SCALE |
| DE APPR. | | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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| | | | | | | | |

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

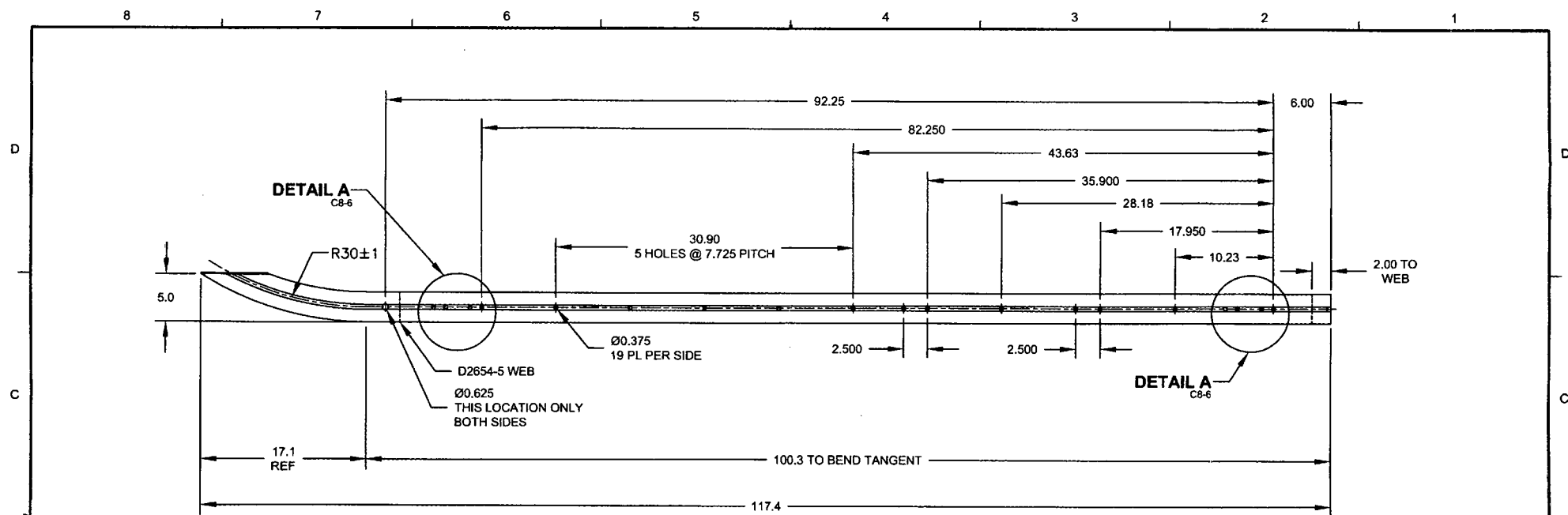
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
| | | | | | | | |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

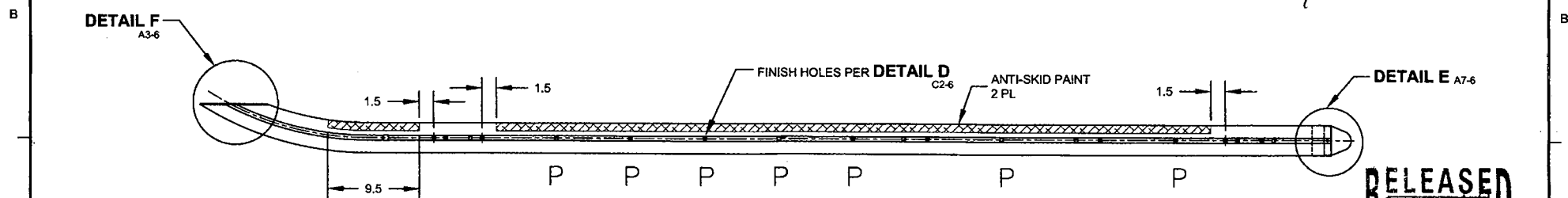
Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
|------|------|----------------------------------|-----------------------------|---------------------------------|----------------|---------------------------|-----------------------|--------------------------|
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| | | | Initial Chief Eng | Action Description Chief Eng | Sign & Date | | | |
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NOTE: Date & initial all entries



D2650-5 BENDING/DRILLING DETAIL



D2650-5 ASSEMBLY/FINISHING DETAIL

| | | | |
|---|---|---|--------------|
| DESIGN | DS | DART AEROSPACE USA, INC | |
| DRAWN | AJS | PORT HADLOCK, WA | |
| CHECKED |  | DRAWING NO. | REV. F |
| MFG. APPR. |  | D2650 | SHEET 4 OF 6 |
| APPROVED |  | TITLE | SCALE |
| DE APPR. |  | 206/407 SKIDTUBE ASSEMBLIES | NTS |
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RELEASED
08.09.22/117

171053

Dart Aerospace Ltd

| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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| DATE | STEP | Description of NC Section A | Corrective Action Section B | | | Verification Section C | Approval Chief Eng | Approval QC Inspector |
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NOTE: Date & initial all entries

Dart Aerospace Ltd

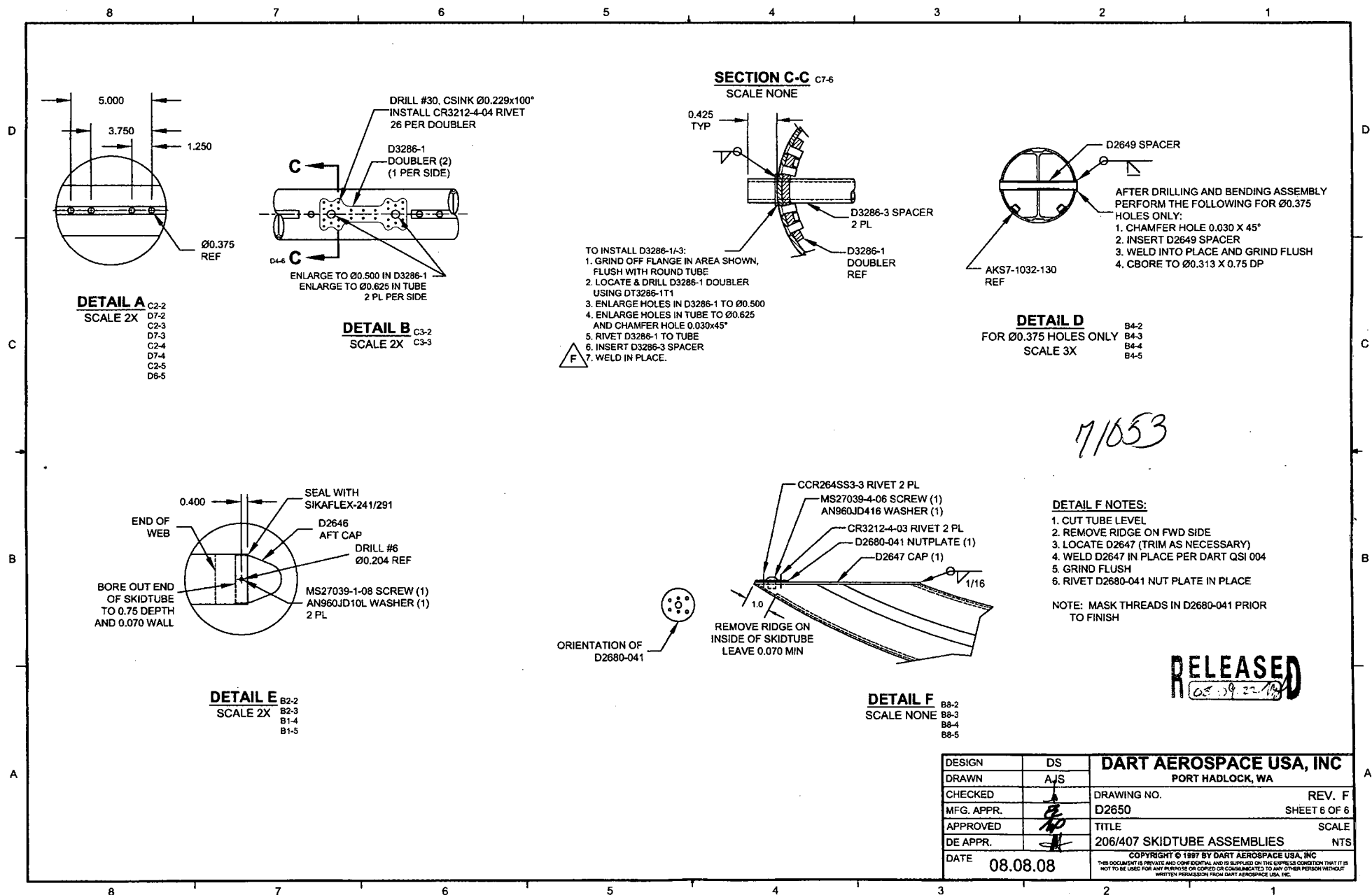
| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

| NCR: | | WORK ORDER NON-CONFORMANCE (NCR) | | | | | | |
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NOTE: Date & initial all entries



| W/O: | | WORK ORDER CHANGES | | | | | |
|------|------|--------------------|----|------|-----|-------------------------------------|--------------------------|
| DATE | STEP | PROCEDURE CHANGE | By | Date | Qty | Approval Chief Eng / Prod Mgr | Approval QC Inspector |
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